

Date: Wednesday, 6/6/2007 3:45:56 PM  
 User: Kim Johnston

## Process Sheet



Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 32841	
Estimate Number : 10494	
P.O. Number : <i>NIA</i>	Part Number : D32045
This Issue : 6/6/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 30896	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 6/27/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature] 07.06.07</i>	
Comment : Est:C 05.08.11 Added Step 25 KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
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Comment: Qty.: 0.3059 f(s)/Unit Total : 1.8352 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)  
 (M6061T6B0.375x01.250) Batch: *M103755*

*ml 07/08/28*

*6*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

*ml 07/08/28*

*6*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1- Machine as per Folio FA344 and Dwg D3204  
 2- Deburr  
 Identify as D3204-5

*ml 07/08/28*

*6*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/08/29*

*6*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SG 07.08.29*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 09/08/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32841

Part Number: D32045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/08/29 @*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(6)*

Comment: FINAL INSPECTION/W/O RELEASE

*DD 07/08/29*

Job Completion



*U 07-08-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

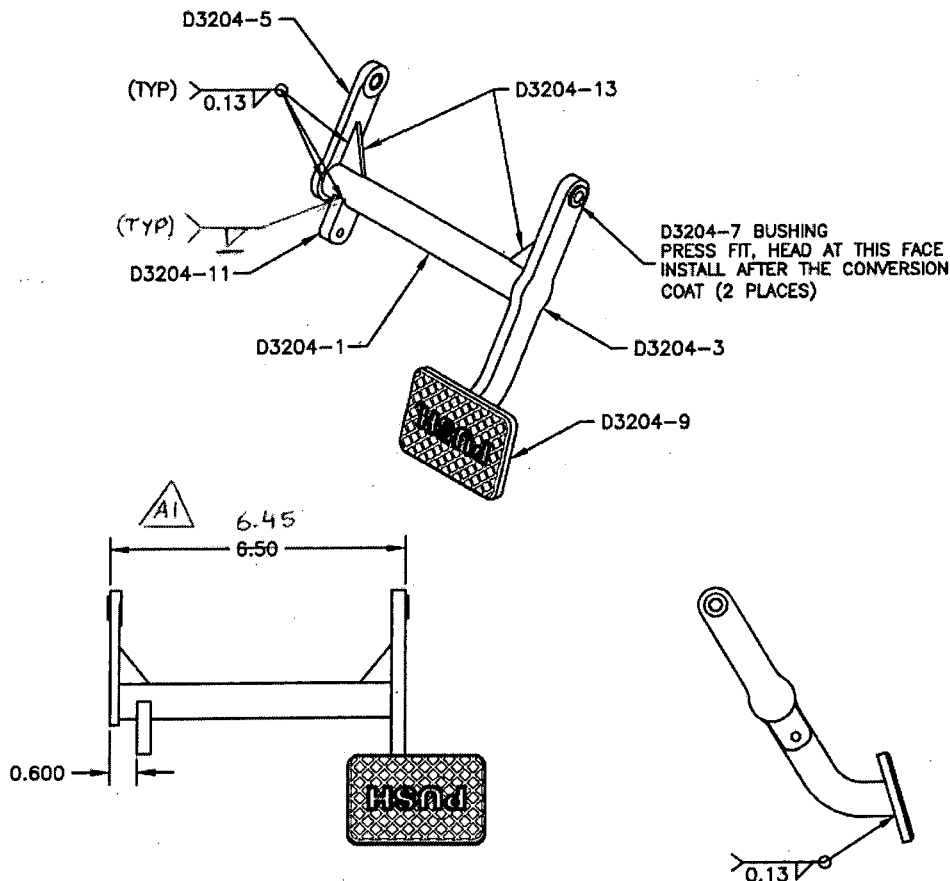
**NOTE:** Date & initial all entries



**DART**

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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

**RELEASED**  
04.04.30



### **D3204-041 RELEASE PEDAL ASSEMBLY**

#### **NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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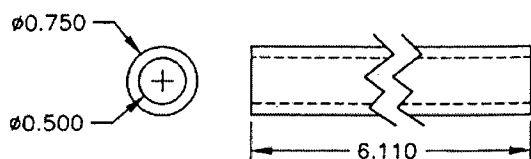
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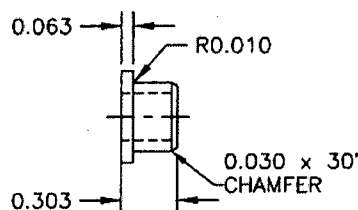


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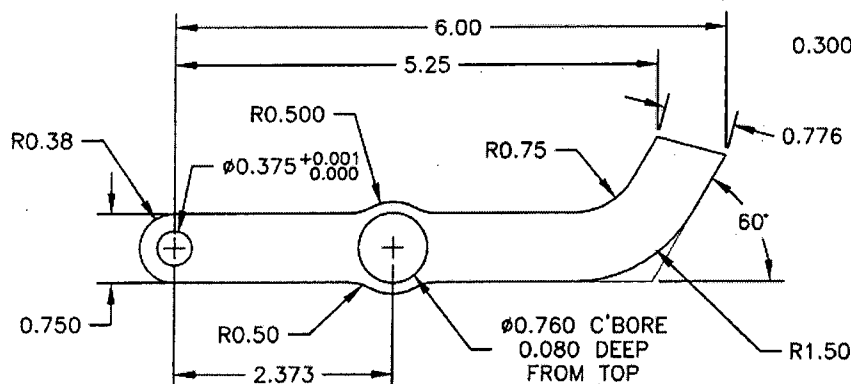
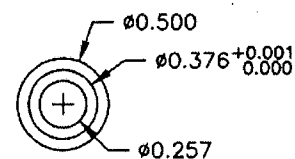
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04.04.05 [Signature]



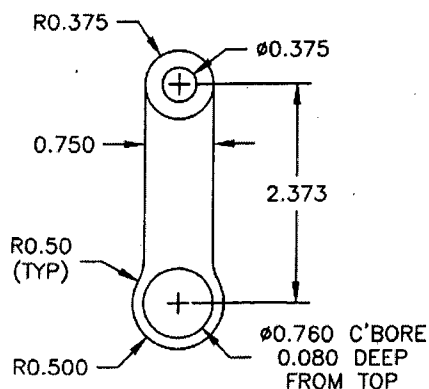
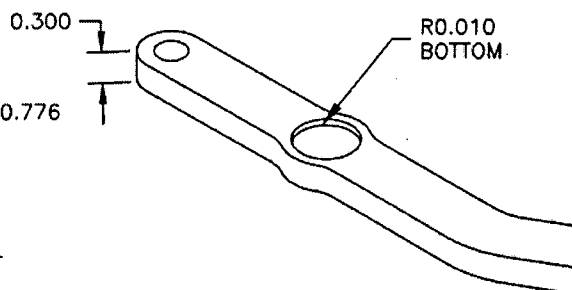
2 D3204-1 TUBE  
SCALE 1:2



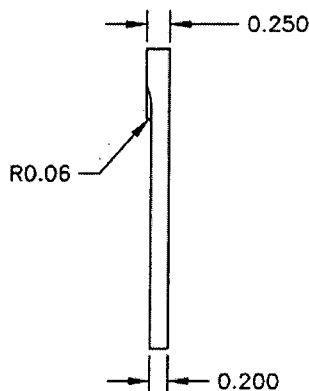
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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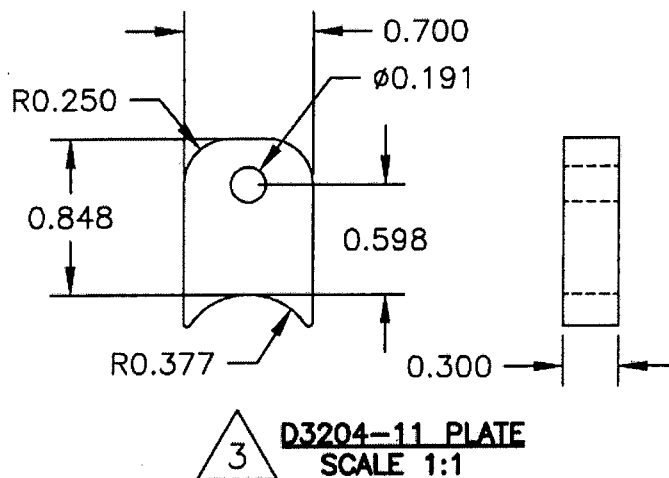
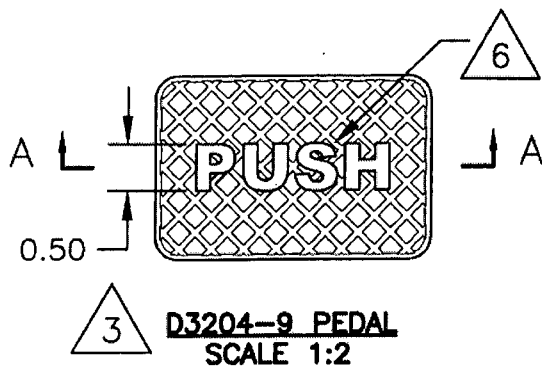
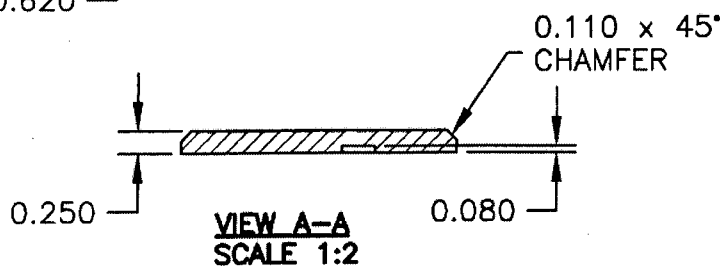
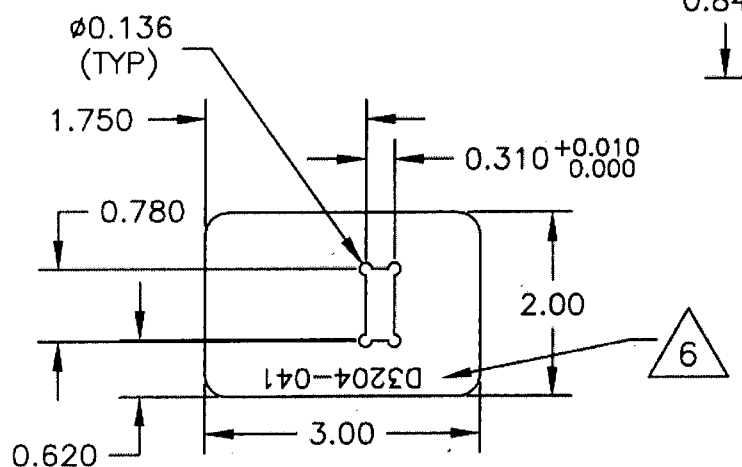
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